

Date: Tuesday, 3/20/2007 12:03:49 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HI-STEP LEG ASSEMBLY
 Job Number : 31339
 Estimate Number : 10385
 P.O. Number : *N/A* Part Number : D3065041
 This Issue : 3/20/2007 S.O. No. : *N/A* Drawing Number : D3065 REV B
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 30466 Material : *N/A*
 Written By : Due Date : 4/10/2007 Qty: *63* Um: Each
 Checked & Approved By : *07.03.20*
 Comment : Est Rev: C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 31339A STEP SPACER



Comment: Sub-Component STEP SPACER

D3065-1 B *29750 x 39 mx, B 31794A x 24 mx-*

2.0 31339B STEP SPACER



Comment: Sub-Component STEP SPACER

D3065-3 B *27590B x 15 mx, B 28738B x 3 mx, B 23618 x 1 mx, B 31794B x 4 mx-*

3.0 31339C STEP LEG



Comment: Sub-Component STEP LEG

D3065-5 B *32032C x 126 mx-*

4.0 31339D STEP SPACER



Comment: Sub-Component STEP SPACER

D3065-7 B *31794D x 60 mx, B 28738D x 3 mx-*

5.0 MS20470AD44 Rivet, Universal Head



Comment: Qty.: 30.0000 Each(s)/Unit Total : 1800.0000 Each(s)

Rivet, Universal Head

Pick:

Qty Part Number Description Batch

30 MS20470AD4-4 Rivet *m104214 x 138 mx, m104291 x 1752 mx*

mf 07/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/06/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 12:03:49 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 31339

Part Number: D3065041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

MF 07-06-14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07-06-14

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA 20, 19, 18, 17

PE 07-06-14

9.0

QC21

FINAL INSPECTION/W/O RELEASE



07.06.15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-06-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

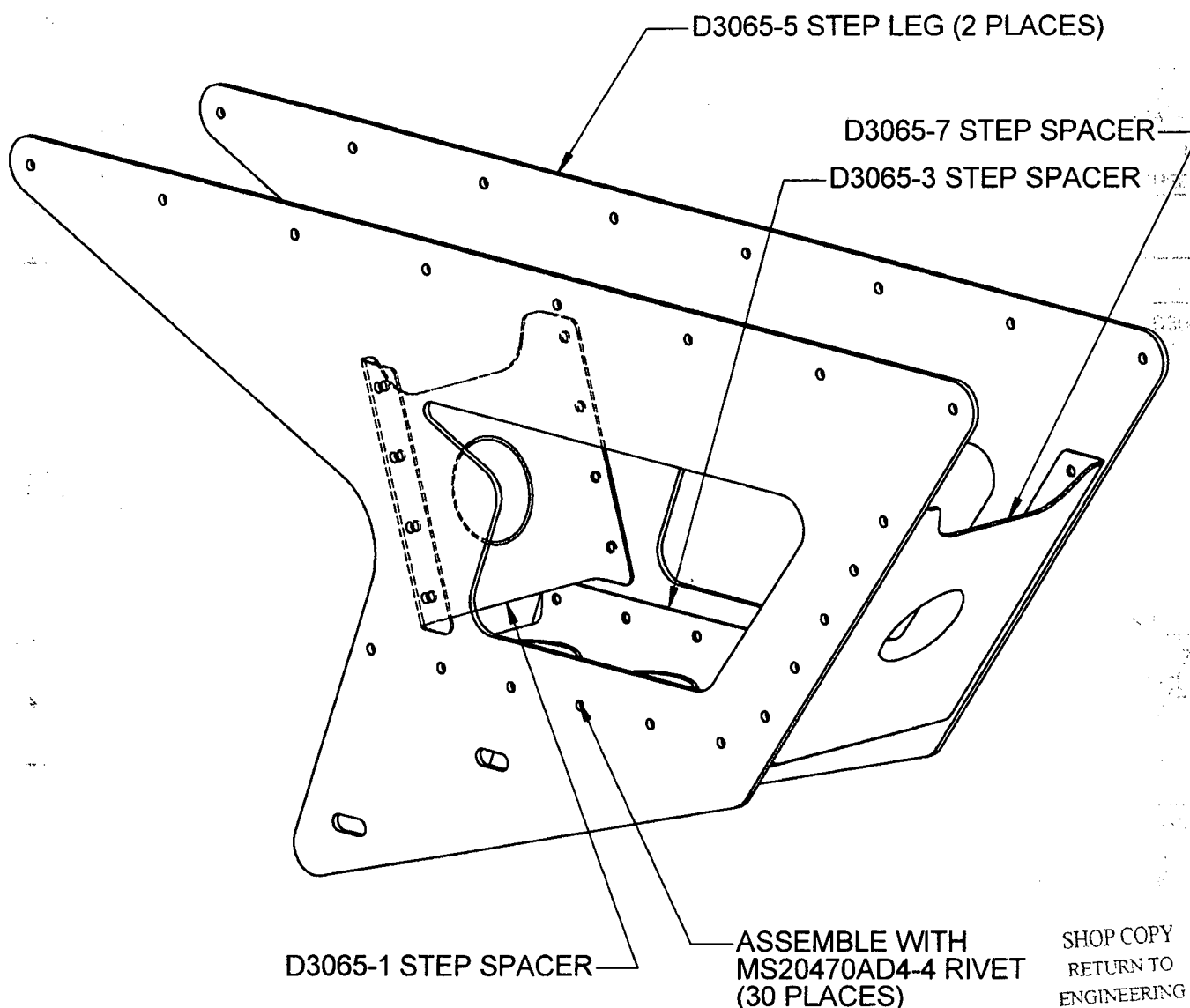
NOTE: Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY SCALE 1:2	
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-041 STEP LEG ASSEMBLY

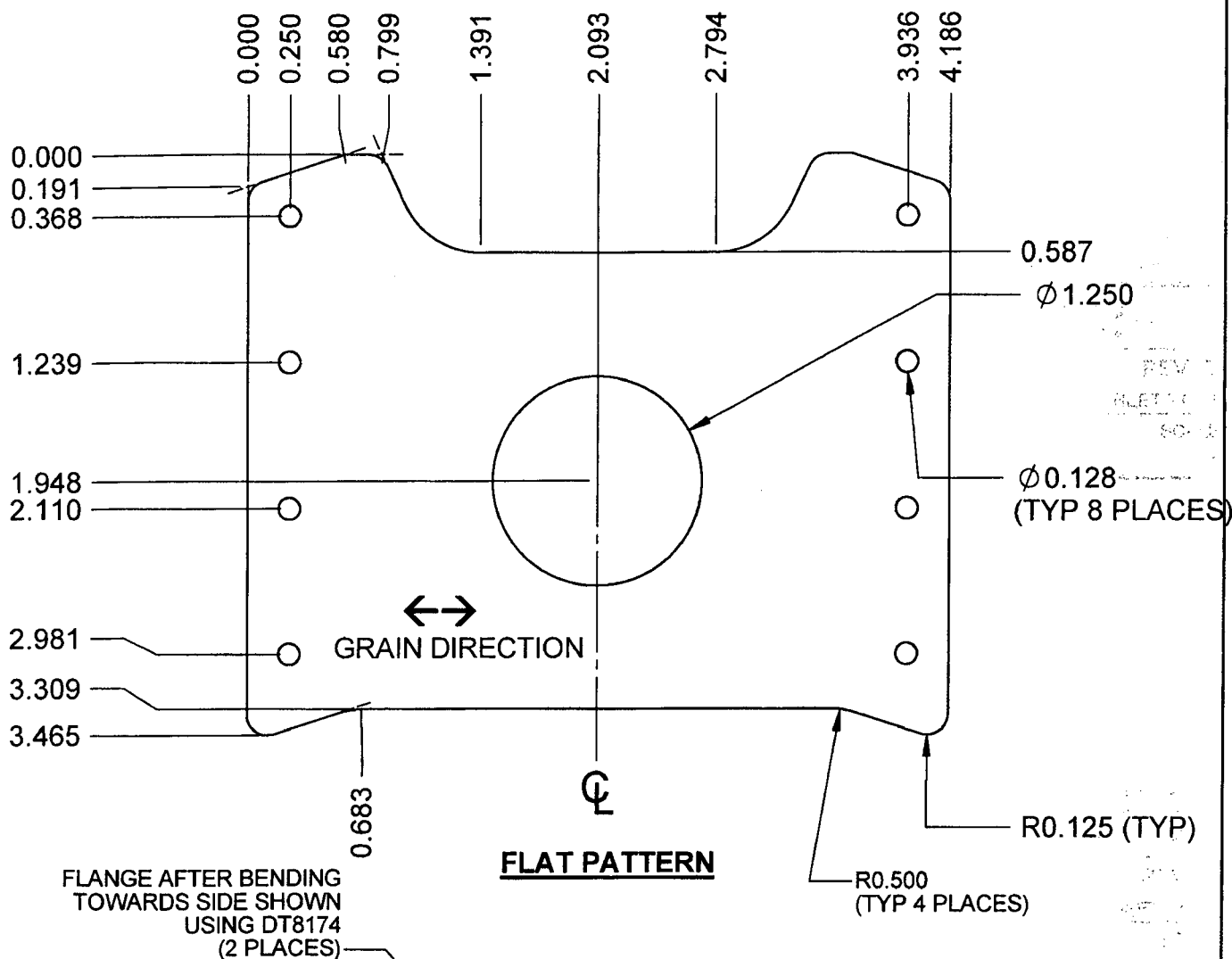
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



RELEASED

cl. de-20

D3065-1 STEP SPACER

BEND DETAIL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

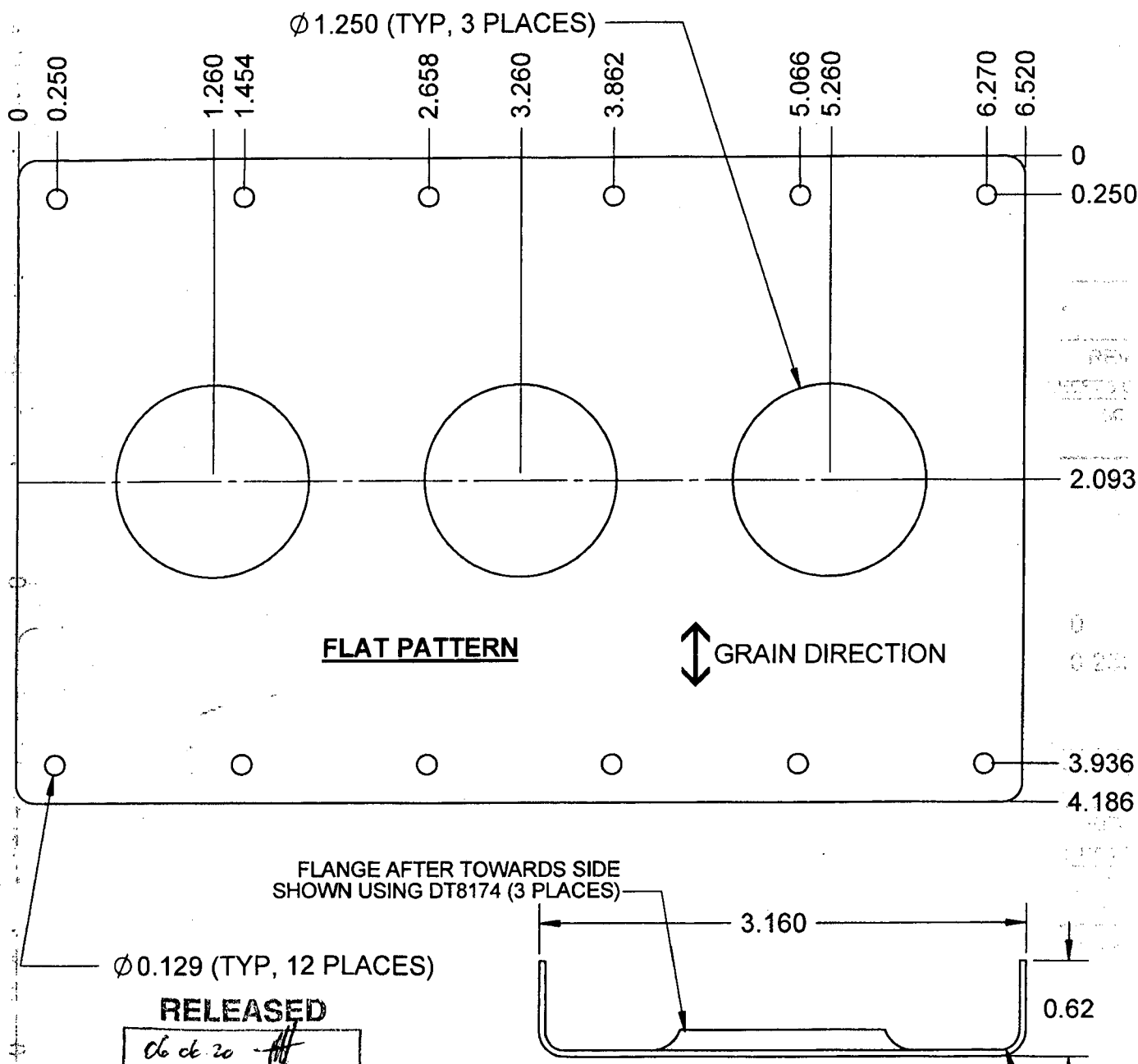
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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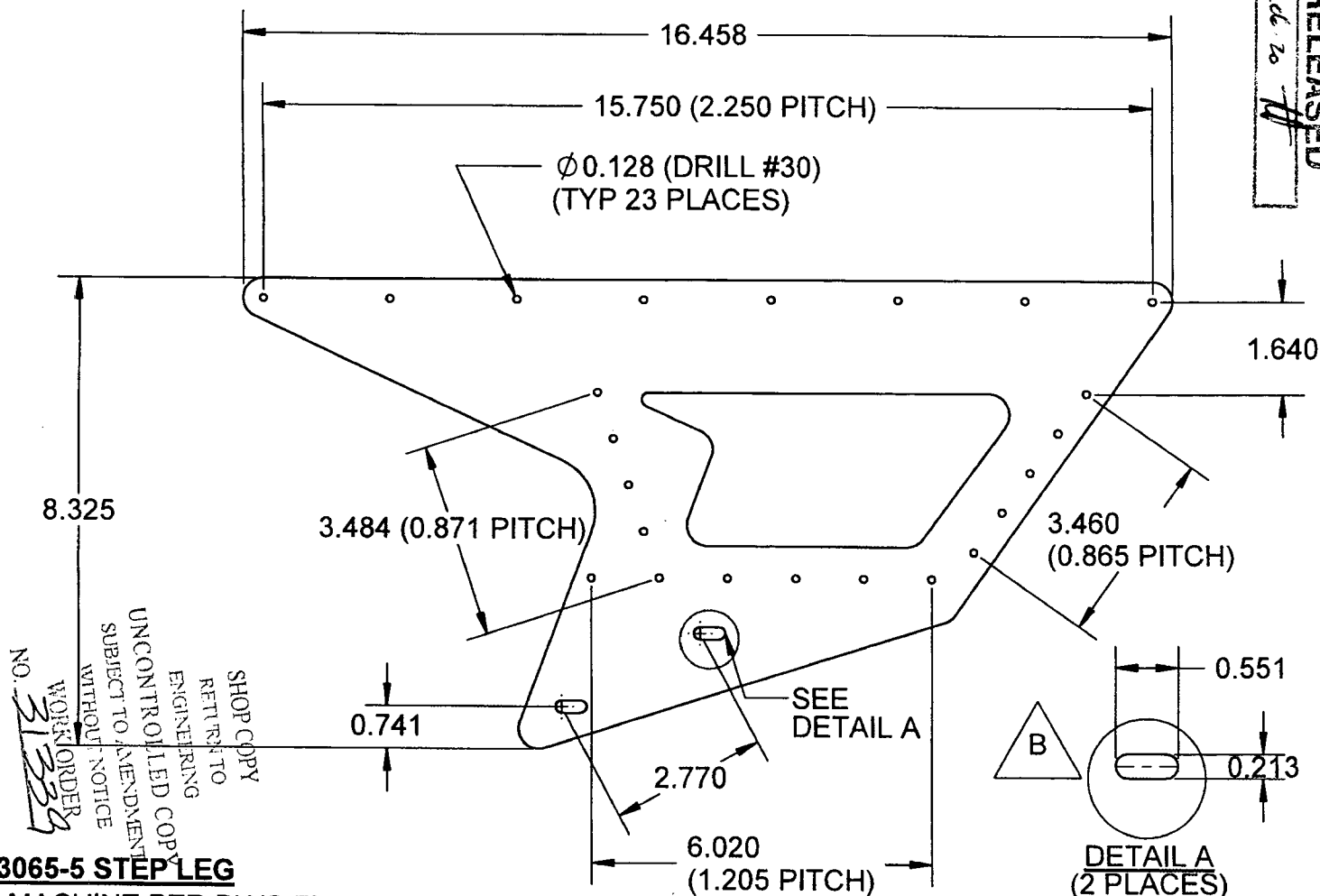
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PH	CB	
DATE	DRAWING NO.	REV. B
06.05.23	D3065	SHEET 4 OF 5
	TITLE	SCALE
	STEP LEG ASSEMBLY	1:3

RELEASED
06.05.23



D3065-5 STEP LEG

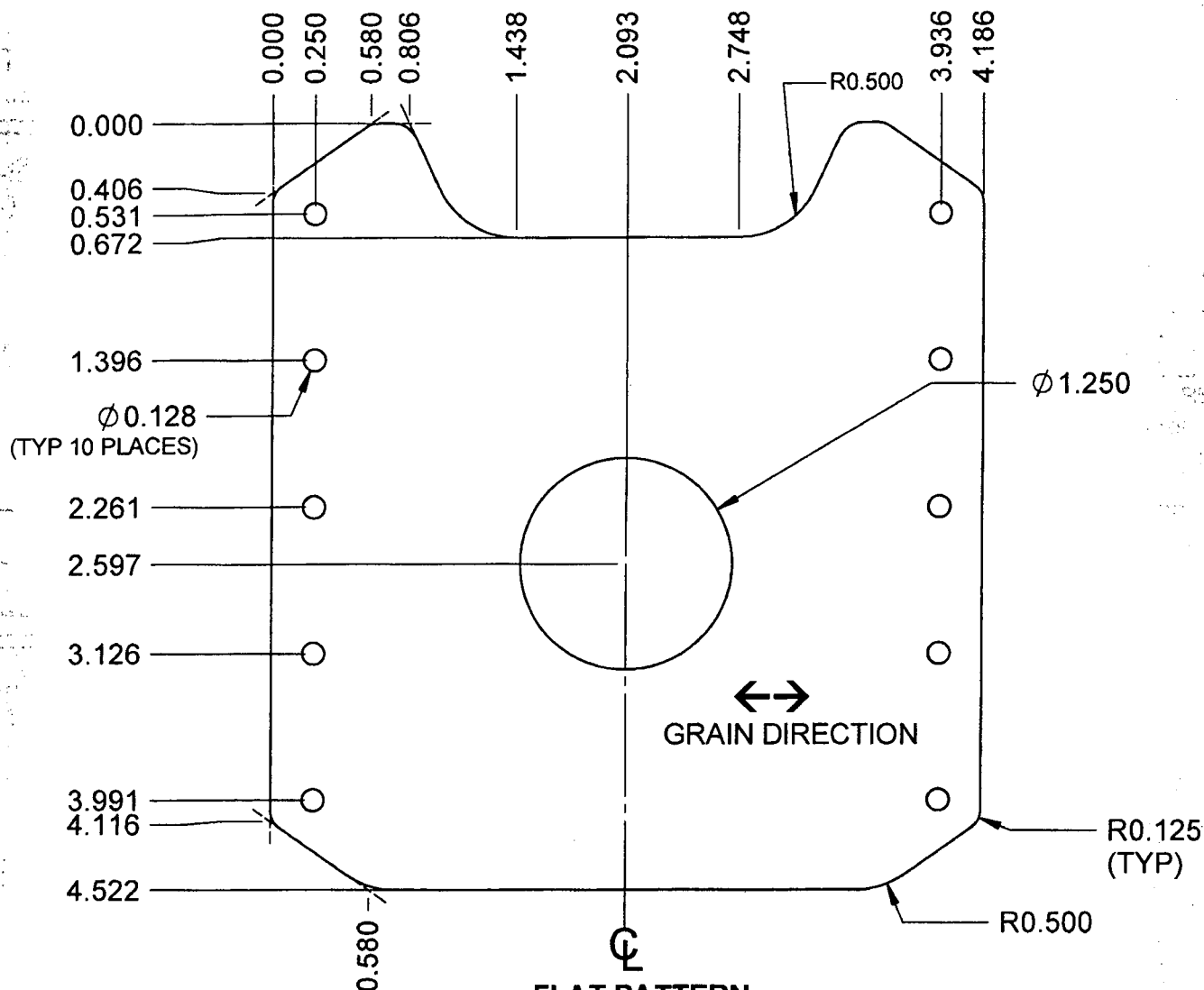
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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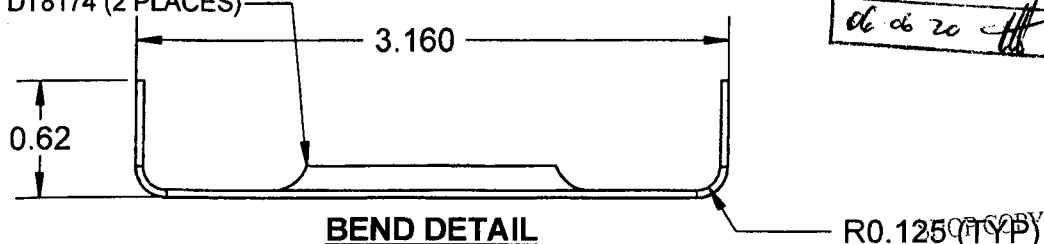


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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



BEND DETAIL

RELEASED

de de ro

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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